

Date: Tuesday, 04/11/2008 2:03:22 PM  
 User: Melanie Fauteux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : SQUARE TUBE

Job Number : 43199 - 2

Estimate Number : 13420

P.O. Number :

Part Number : PB6743001207

This Issue : 04/11/2008 S.O. No. :

Drawing Number : B6743001 P.5/P.16

Prsht Rev. : NC

Project Number : N/A

First Issue : // Type : LARGE FAB ASSY

Drawing Revision : B1

Previous Run : 42603

Material :

Due Date : 11/11/2008

Qty: 10 Um: Ea

Written By :

Checked &amp; Approved By : MF 08-11-04

Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6TS1000W120

6061T6 SQ TUBE 1.00 x 1.00 X .120w



Comment: Qty.: 1.9469 f(s)/Unit Total : 9.7346 f(s)

6061T6 SQ TUBE 1.00X.120

batch: M109928

SAD 08-11-20

2.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- cut to length as per dwg

2- make a 0.090" chamfer on both ends of tube

3- deburr

SAD 08-11-20

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08/11/20 (410)

4.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- drill holes as per dwg

2- make a 0.090" chamfer (100 degree) on both side of the 4 holes

3- deburr

SAD 08/11/24 (10)

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08/11/24

# Process Sheet

ner: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

Number: 43199

Part Number: PB6743001207

Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001225

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bushing

batch:

~~B40272~~ → 8 ~~B24005~~ → 16  
~~B40272~~ → 8 ~~B24005~~ → 16

Cpl 08.11.25

7.0

PB6743001223

Square Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Square Cap

batch:

~~B42604~~ → 6 B42604 → 6

Cpl 08.11.25

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg

Cpl 08.11.25

(x6)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

2- deburr

SAD 08-11-26  
Cpl 08.11.26

9

10.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/11/26

(x6)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/26

(x6)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 438

6/1/04

(6x)

SP

13.0

QC21

FINAL INSPECTION/W/O RELEASE

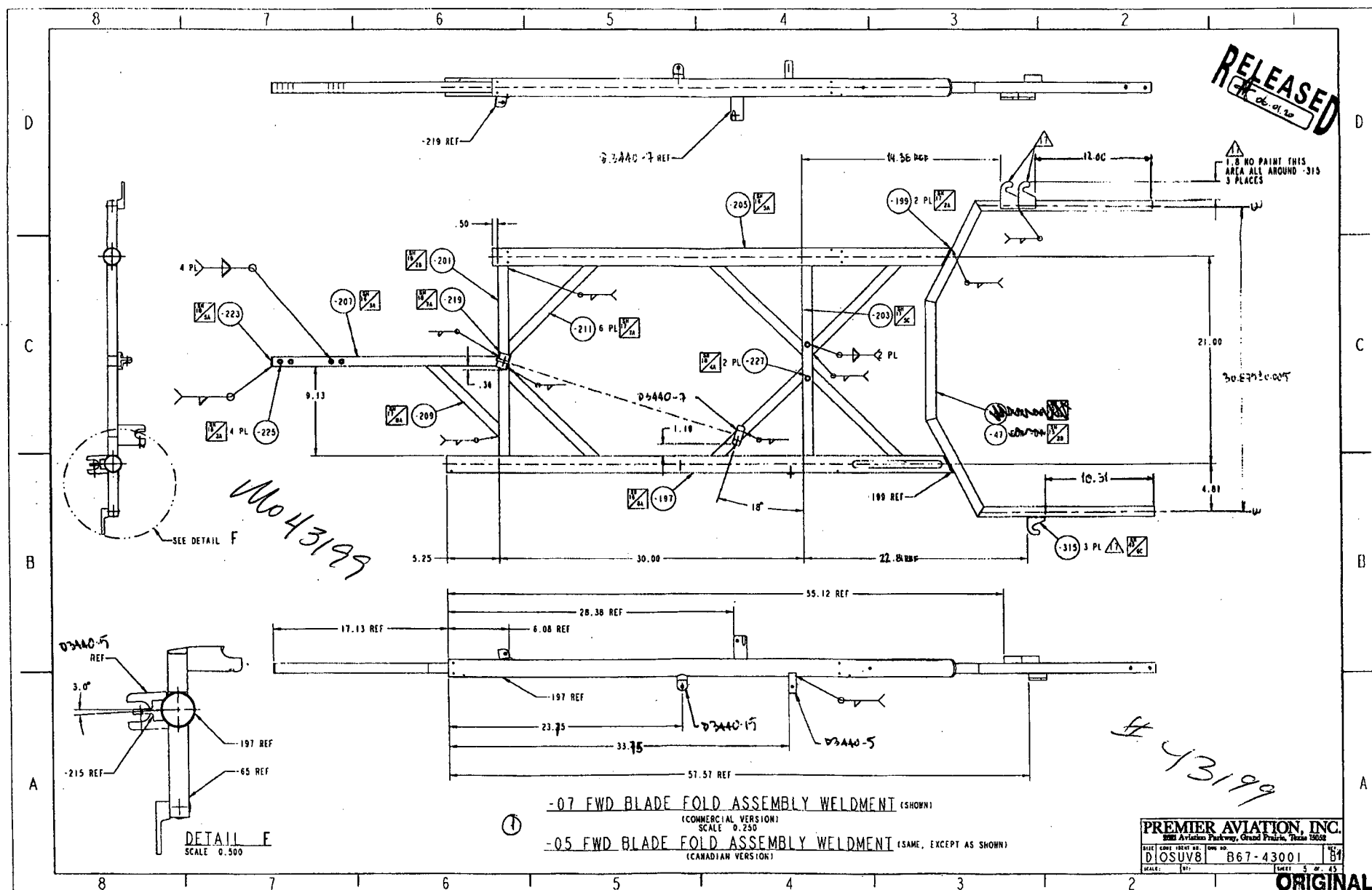


Comment: FINAL INSPECTION/W/O RELEASE

08/11/26

mf 08-11-26

RELEASED  
JUL 01 1962



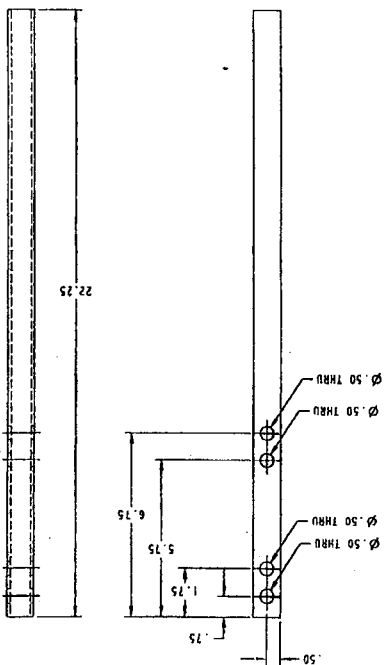
<b>PREMIER AVIATION, INC</b>			
2221 Aviation Parkway, Grand Prairie, Texas 75052			
<b>SIZE</b>	<b>CODE IDENT NO.</b>	<b>OWN NO.</b>	
D	OSUV8	867-43001	
<b>SCALE</b>	<b>NO.</b>	<b>DATE</b>	<b>BY</b>

**ORIGINAL**

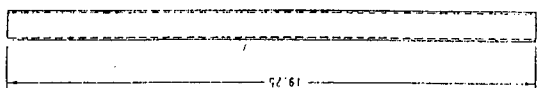
ORIGINAL

PREMIER AVIATION, INC.  
867-43001  
010508  
16 45

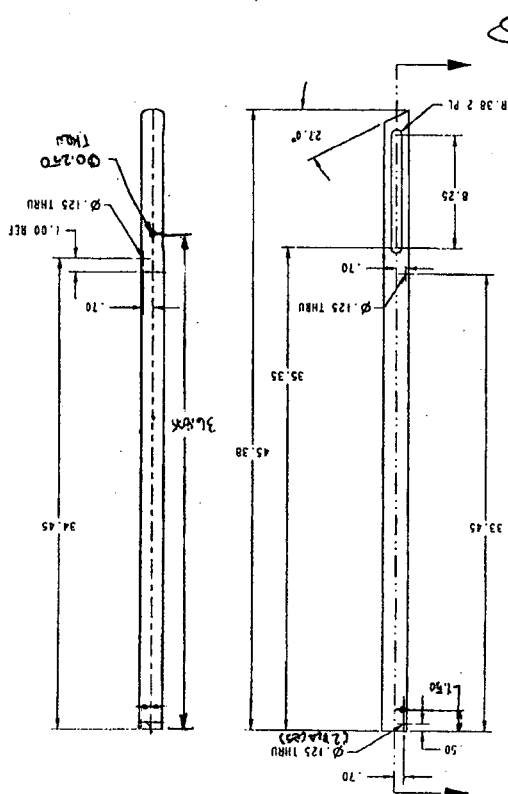
①  
-207 SQUARE TUBE  
MATERIAL: 1.00 SQ X .125 WALL, 6061-T6  
SCALE: 0.500



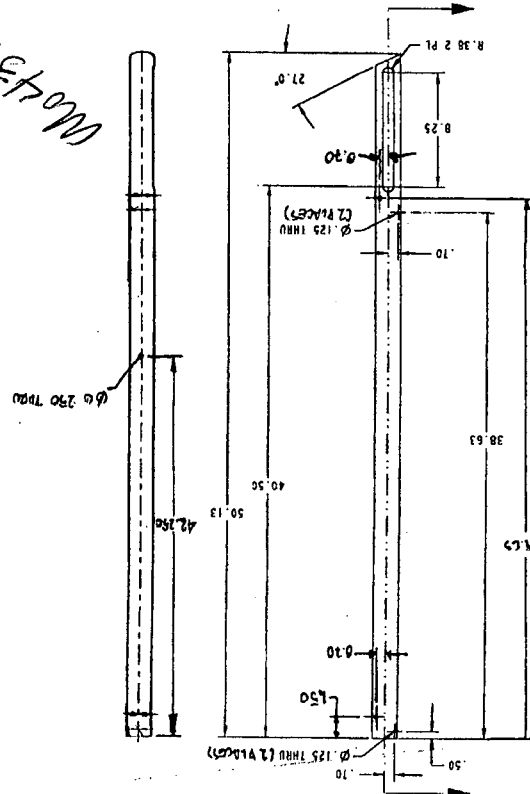
⑤  
-201 SQUARE TUBE  
MATERIAL: 1.00 SQ X .065 WALL, 6061-T6  
SCALE: 0.500



①  
-205 OUTER TUBE  
MATERIAL: 1.75 OD X .065 WALL, 6061-T6  
SCALE: 0.250



①  
-497 OUTER TUBE  
MATERIAL: 1.75 OD X .065 WALL, 6061-T6  
SCALE: 0.250



RELEASED  
06-4-20

